

Date: Friday, 11/18/2005 5:33:14 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET RIB
Job Number	: 24880	Part Number	: D31661
Estimate Number	: 10402	Drawing Number	: D3166 REV A1
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Revision	: A1
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LANDING GEAR	Due Date	: 12/15/2005
Previous Run	: 24596	Qty:	25 Um: Each
Written By	: <u>See comment below</u>		
Checked & Approved By	: <u>See comment below</u>		
Comment	: Est. 02.08.23 New issue KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 5.2500 f(s)/Unit Total : 131.2500 f(s)

304 SQ Tube.75x.75x.065W

(M304TS0750W065)

Material: 304/316 SS tube 0.065" wall

Batch M/8796 Pm' 05-12-23

(25)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut 3/4" x 3/4" square tubing 60.00" long.

Pm' 05-12-23

(25)

P70

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio FT004.

Pm' 05-12-29

(25)

P10

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302)

06-01-04 25

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

Pm' 06-01-03

(25)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector	

Part No: D3166-1 PAR #: _____ Fault Category: Prod / Landing ^{FAB. ASS' LARGE} NCR: (Yes) No DQA: (Yes) Date: 06/01/05
 QA: N/C Closed: (Yes) Date: 06.01.05

NCR: <u>24880</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-12-23	2	2 lengths were cut 12" too short + measured off of wrong marker line.	<i>[Signature]</i>	Scrap 1 2, and replace 1 to keep qty of 25. Identify 2 scrap pieces with batch # and place back into mat'l stock for something else.	<i>[Signature]</i> 05-12-23	05-12-23	<i>[Signature]</i>	05-12-23
06-01-03	3	1st rib bent too wide, rollers weren't in enough. Was bent twice to bring rib in, but rib would not fit sig, was bolted to wide the 1st time.	<i>[Signature]</i>	Scrap & replace	<i>[Signature]</i> 06-01-03	06-01-03	<i>[Signature]</i>	06-01-03

NOTE: Date & initial all entries

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Job Number: 24880

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



(25)

Comment: DOCUMENT CONTROL

Inspection Level 21

Sus 06/01/05

(25)

SP 06/01/05

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No : 0024880
Project Name : D3166-1
Project For : WK550
Work Order Type : Main
Main WO Number :
House Part Number : D3166-1
Description : Basket Hoop
Manufactured : Yes
Amount Req'd : 25
Amount Done : 0
Start Date : 11-18-05
Est Finish Date : 12-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00